



Dart Aerospace Ltd.
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D135-1027-243
Job Sheet 170192

Accounting Job RD17-1027-01



Part No: D135-1027-243

Job Qty: 1 ea

Part Name: MID HEIGHT AFT Crosstube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/11/18

Job Tracking No:

Due Date: 1/19/18

Created By: Mario Poulin

Type: R+D

Description:

Note: D135-1027-243 REV.B IPP REV:A 17.09.08 NEW ISSUE DD VERF:DP IPP REV:B 17.10.24 AS PER DWG
REV.B DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/18/18	1/18/18	0.00	0.00	Start Up Container		
100	HandFinish	1 pcs	1/18/18	1/18/18	0.00	0.25	HandFinish1		
110	QC	1 pcs	1/18/18	1/18/18	0.00	0.00	QC7-1		APR 26 2018
120	HandFinish	1 pcs	1/18/18	1/18/18	0.00	0.25	HandFinish4		APR 26 2018
130	QC	1 pcs	1/18/18	1/18/18	0.00	0.00	QC5		38
140	SprayPaint	1 pcs	1/19/18	1/19/18	0.00	1.00	Spray Paint		APR 27 2018
150	QC	1 pcs	1/19/18	1/19/18	0.00	0.00	QC14		38
170	Packaging	1 pcs	1/19/18	1/19/18	0.00	0.00	Packaging3-1 L6050		MAY 02 2018
180	QC21-SA	1 Ea	1/19/18	1/19/18	0.00	0.00	QC21		MAY 07 2018

Part Op 100 - ***PRIOR TO CHEMICAL CONVERSION*** SCRIBE DART P/N AND B/N ON INSIDE OF CUFF PER QSI 044 6.4
Descriptions: 120 - INSTALL THREADED ROD AS PER DWG AND APPLY LOCKTITE 263 (NOTE 9) AND SEAL BETWEEN THE
NUT AND CROSSTUBE USING SEALANT(NOTE10) locktite 138857 Proseal 138784 exp 7/18
140 - ***MASK PRIOR TO PRIME AND PAINT AS PER NOTE11, BOTH ENDS*** 1- PRIME INSIDE AND OUTSIDE
PER QSI005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER) BATCH: 138408 2- PAINT OUTSIDE SURFACE AS
PER QSI005 4.2.2.4 (FLOAT SKIDTUBE PAINT) BATCH: 138819 3- COAT INSIDE SURFACE WITH LPS
PROXYON AS PER DWG, QSI005 4.8 4- AFTER FINISH APPLY A 1 INCH CENTER LINE ON TOP OF CROSSTUBE
WITHIN 0.1" OF CENTERLINE QSI 044 6.1(SEE NOTE 12 AND 13)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D135-1027-253 S053471	①	0	0	0
	D5511-1 16507	②	7	0	0
	MS35650-304 FM137878	③	60	0	0
	NAS1149D0363J S015269	④	4,315	0	0

Part Specifications



Container No: S066271



Part: D135-1027-243

Job No: 170192

Serial No/Batch: S066271

Revision: B

Inspector:

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ex 1/11/18 10:29 AM dart.poulin.mario

P.T.O.

cmd 19 Jun 2019



DQA: _____ Date: _____ WORK ORDER NON-CONFORMANCE / UPDATE
QA Closed: CPM Date: JUN 19 2019 Work Order update only ☐

Work Order: <u>170192</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS															
Part No. <u>D1357027-243</u>		Rework ☒ Scrap ☐ Use-as-is ☐		Skid-tube Machining ☐ Thermoforming ☐ Large Fab ☐		Cross tube Small Fab ☐ Finishing ☐ Composite ☐		Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐		Engineering ☒ Quality ☐ Other ☐									
NCR No. <u>19-7182</u>		Suspected Unapproved		QTY Effective : _____															
Date: <u>16/5/2</u>		Step #: <u>140</u>		Disposition															
Description Work Order Deviation				MRE (QSI042) Approval DAS 12 16/5/2 9-89															
Dug cells for Procyon on inside surface of crashtube. Not required. Difficult to apply and process not done on other crashtubes. Dug will be revised to remove procyon before STC approval MAY 02 2018				Completed By DAS 12 16/5/2 9-89															
				Lead hand / Supervisor Approval Verification DAS 9 9-89 18-05-17															
				QC / QA Coordinator Approval DAS 9 9-89 18-05-17															
Root Cause				FAULT CATEGORY															
☐ Environment				☐ Pressure/Forced				☐ Temperature/Cure				☐ Power Loss/Surge				☐ Positioned Wrong			
☒ Design				☐ Bending				☐ Set-up				☐ Folio/Program				☐ Outside Dimensions			
☐ Doc/Data				☐ Centre Not Concentric				☐ BOM/Route				☐ Grain				☐ Over/Under tolerance			
☐ Equip/Tooling				☐ Cracks				☐ Broken/Damage/Defect				☐ Weld				☐ Part Incorrect			
☐ Handling/Pre				☐ Crimp/Kink/Ripple/Wave				☐ Inspection Incomplete/Unqualified				☐ Wrong Stock Pulled				☐ Part Lost/Missing			
☐ Material				☐ Cuffs				☐ Contamination				☐ Out of Sequence				☐ Part Moved			
☐ Internal Transport				☐ Crushing				☐ Countersink				☐ Off-set				☐ Drawing			
☐ Tribal Knowledge				☐ Heat Treat				☐ Cut Too Short				☐ Mislabeled				☐ Finish			
☐ LOA				☐ Wave/Twist in Tube				☐ Instructions Incomplete/Unclear				☒ Fit/Function				☐ Misread			
☐ Substation				☐ Marks/Chatter				☐ Drill Holes				☐ Misaligned/off center				☐ Turning Sequence			
Past Expiry Date																			
Misidentified																			
				OTHER :															